

Work Order ID 110058

December-17-13 9:07:13 AM

110058

Page 1

Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Deck Plate Fwd
 Start Date: 12/17/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2364	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2364 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2- Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
12/27/13
14/2/17

7 0 Jm 14-02-7
7 0 Jm 14-02-7
7 _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				7x			14/02/07
Small Fab	Memo	0.00							
Small Fab	1- counter sink holes as per dwg D23642- deburr if necessary								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				7			
Quality Control	Memo	0.00							
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				7			7/6/14-10
Hand Finishing	Memo	0.00							

DAS
36
9-89

DAS
27
9-89

4/2/17

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Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 126878</i> Memo START TIME: <i>1:55</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:25</i>	0.00 0.00				<i>7.0</i>	<i>14-2-10</i>		<i>DAS 34 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>7</i>			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST220A</i> Memo	0.00 0.00				<i>7x</i>	<i>DAS 28 9-89</i>	<i>14-02-11</i>	

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Item ID: D2364

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deck Plate Fwd

Stop

NS2

Start Date: 12/17/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

*14-02-12**14-02-12*

Picklist Print

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Page 1

Work Order ID: 110058

Parent Item: D2364

Parent Item Name: Deck Plate Fwd

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

252.7489

0.6469

~~2.7237896~~

5

Jm14-02-7

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

252.7489

119916

0.2

121197

21.34

123096

11.4

123654

11.64

123701

16.1039

125341

87.94

125636

104.125

127866

127866.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART AEROSPACE LTD		Work Order:	110058
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.624"	-		✓	Jkmo,
Ø0.171	+0.005/-0.000	0.172"	-		✓	
0.354	+/-0.010	0.354"	-		✓	
11.242	+/-0.010	11.242"	-		T	
3.031	+/-0.010	3.031"	-		✓	
1.903	+/-0.010	1.903"	-		✓	
1.128	+/-0.010	1.128"	-		✓	
0.354	+/-0.010	0.354"	-		✓	
1.340	+/-0.005	1.340"	-		✓	
2.326	+/-0.010	2.326"	-		✓	
3.312	+/-0.010	3.312"	-		✓	
4.298	+/-0.010	4.298"	-		✓	
5.284	+/-0.010	5.284"	-		✓	
6.151	+/-0.010	6.151"	-		✓	
6.270	+/-0.010	6.270"	-		✓	
0.354	+/-0.010	0.354"	-		✓	
3.031	+/-0.010	3.031"	-		✓	
Ø0.656	+0.005/-0.000	0.656"	-		✓	
5.003	+/-0.010	5.003"	-		✓	
4.605	+/-0.010	4.605"	-		✓	
1.776	+/-0.010	1.776"	-		✓	
0.980	+/-0.010	0.980"	-		✓	
4.487	+/-0.010	4.487"	-		✓	
7.192	+/-0.010	7.192"	-		✓	
7.567	+/-0.010	7.567"	-		✓	
7.942	+/-0.010	7.942"	-		✓	
Ø0.191	+0.005/-0.000	0.192"	-		✓	
Ø0.197	+0.005/-0.000	0.200"	-		✓	
11.145	+/-0.010	11.145"	-		T	Jkmo
12.181	+/-0.010	12.181"	-		T	
11.378	+/-0.010	11.378"	-		T	
11.776	+/-0.010	11.776"	-		T	
12.173	+/-0.010	12.173"	-		T	
4.690	+/-0.010	4.690"	-		✓	
0.250	+0.005/-0.000	0.253"	-		✓	
3.141	+/-0.010	3.141"	-		✓	
0.171	+0.005/-0.000	0.171"	-	DAS 27	✓	

Measured by: Jm	Audited by: 9-89	Prototype Approval:	N/A
Date: 14-02-7	Date: 14/02/7	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

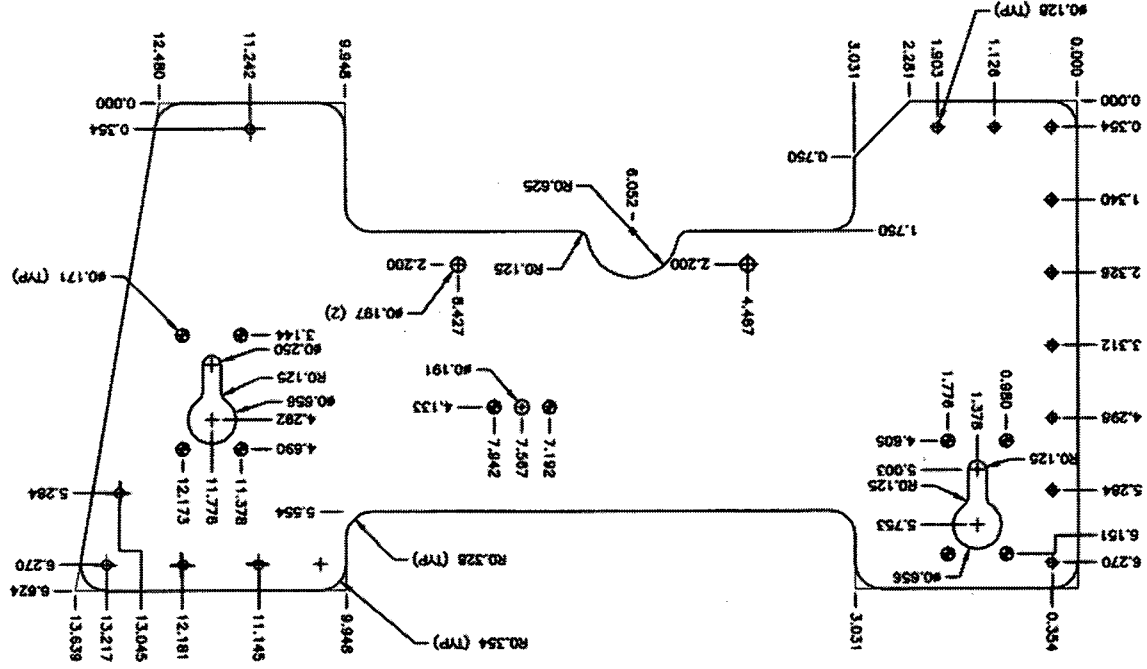
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RELEASED
93/06/22 KG

93/06/22 KE

11058 17-12-11

COUNTER SINK HOLES:
♦ C/SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES BY 05.09.03.01 TO CORRECT CAD ERROR)
• C/SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (90-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED